



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563

Job Sheet 176549



Part No: D2563

Job Qty: 4 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/25/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/11/18	0.00	0.00	Start Up Large Fab-2		D.M.L 18-4-30
100	Large Fab	4 pcs		5/11/18	0.00	5.88	Large Fab 2		A CPC
110	QC	4 pcs		5/11/18	0.00	0.00	QC9		18-05-02
120	QC	4 pcs		5/11/18	0.00	0.00	QC5		18-05-02
130	HandFinish	4 pcs		5/11/18	0.00	1.07	HandFinish1		SA 18-05-04
140	QC	4 pcs		5/11/18	0.00	0.00	QC7		CPC
150	Large Fab	4 pcs		5/11/18	0.00	5.88	Large Fab 2		CPC
160	QC	4 pcs		5/11/18	0.00	0.00	QC10		24 2018-05-10
170	QC	4 pcs		5/11/18	0.00	0.00	QC5		24 2018-05-10
175	HandFinish	4 pcs		5/11/18	0.00	1.07	HandFinish2		SA 18-05-10
180	Powdercoat	4 pcs		5/11/18	0.00	0.67	Powdercoat1		DR 18-05-10
190	HandFinish	4 pcs		5/11/18	0.00	1.07	HandFinish3		DEB 18-05-11
200	QC	4 pcs		5/11/18	0.00	0.00	QC3		38
210	Packaging	4 pcs		5/11/18	0.00	0.00	Packaging3		9-88
220	QC21-SA	4 Ea		5/11/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: _____

M138760 START: 2:15. O.T. 300° FINISH: 2:45.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	4 Ea (1 ea)	90-Start up Operation	50145527
D2561	Lug	8 Ea (2 ea)	90-Start up Operation	x6 5063399
D2564	Mounting Angle	8 Ea (2 ea)	90-Start up Operation	x6 5052121
D2673-34	End Plate	4 Ea (1 ea)	90-Start up Operation	x3 5052885
D2673-34	End Plate	4 Ea (1 ea)	150-Large Fab	x3 5052885

ring walk M138761

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	4	147	0
	D2561	8	12	0
	D2564	8	11	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Deviation		Disposition			
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 04/30/18 Container No: S067054 Part: D2563 Job No: 176549 Serial No/Batch: S067054 Revision: _____ Inspector: _____					
FAULT CATEGORY					
Enviro _____ Do _____ Equip/T _____ Handling/Pre _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____		ire/Forced _____ ig _____ Not Concentric _____ Crimp/Kink/Ripple/Wave _____ Cuffs _____ Crushing _____ Heat Treat _____ Wave/Twist in Tube _____ Marks/Chatter _____ ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
OTHER : _____					

150-Large Fab	D2673-34	4	45	0
	D2673-34	4	45	0

Part Specifications

Specifications could not be found.

Plex 4/25/18 2:49 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition						
Root Cause		FAULT CATEGORY								
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____						
Misidentified ☐		Past Due ☐								